

Ship 30-31/10 /

Dart Aerospace Ltd.

Date: Thursday, 25/10/2007 2:35:02 PM  
User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP WELDMENT		
Job Number	: 35402			Part Number	: D3562042		
Estimate Number	: 12577			Drawing Number	: D3562 UNDER REVIEW		
P.O. Number	:			Project Number	: N/A		
This Issue	: 25/10/2007 S.O. No. :			Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : LARGE FAB ASSY			Due Date	: 01/11/2007 Qty: 1 Um: Each		
Previous Run	: 35263			Comment	:		
Written By	:			Comment	:		
Checked & Approved By	:			Comment	:		
Comment	: Est Rev:A New Issue 06-11-09 JLM Est rev B ECN 987 07.10.09 EC verified by: DD			Comment	:		

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Qty Part# Description Batch: 1 D2622-120C Extrusion 34694	
		Check Material for any Dents or Defects	
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		1-Cut D2622 extrusion as per Dwg D3562	
		2-Deburr and bevel ends for welding	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 35402

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



10/10/29

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 D3560042 ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

ARM WELDMENT B34475

10/07-10-27

7.0 D3560044 ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

ARM WELDMENT

Batch: B34477

10/07-10-27

8.0 MS20600AD4W5 Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total : 36.0000 Each(s)

Blind Rivet

batch: M105125

10/07-10-27

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Transfer drill Rivet holes as per dwg D3562.

10/07-10-27

2-Touch-up rivet holes with alodine as per dwg d3562

10/07-10-27

3-Rivet legs using Magnabond as per dwg D3562.

10/07-10-27

\*\*\*\*\*Ensure to wipe off any excess magnabond \*\*\*\*\* B104677

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/10/29 6D

11.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D2734 End Cap B34485

10/07-10-29 10

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 LARGE FAB 1



LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M105058

*10/07/2007*

2-Grind end cap welds flush as per Dwg D3562

*10/07/2007*

13.0 QC9



VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*10/07/2007* (1)

14.0 QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*10/07/2007*

15.0 POWDER COATING



(+) TOUCH-UPS ATODING END-CAPS

*10/07/2007*

Comment: POWDER COATING

*M105914*

(1)

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*10/07/2007*

16.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



(1K)

Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

*10/07/2007*

Batch: M106030

17.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



(P10)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*10/07/2007*

18.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

*10/07/2007* (1)

Pick Assembly Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-10- 30	1A	Install bushing 10808 #B <u>32896</u>	MF	07-10- 30	2		
07-10- 30	1B	Suspect level QC #5	SC	07-10- 30 (X)			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #:

Machine Or Operation:

Description :

19.0

QC21

FINAL INSPECTION/W/O RELEASE



07.10.31

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



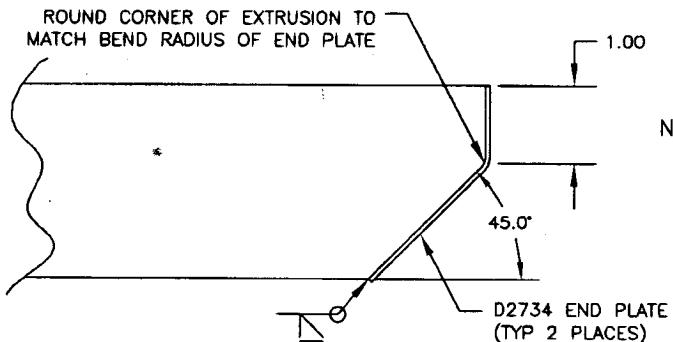
4 ST.10.31

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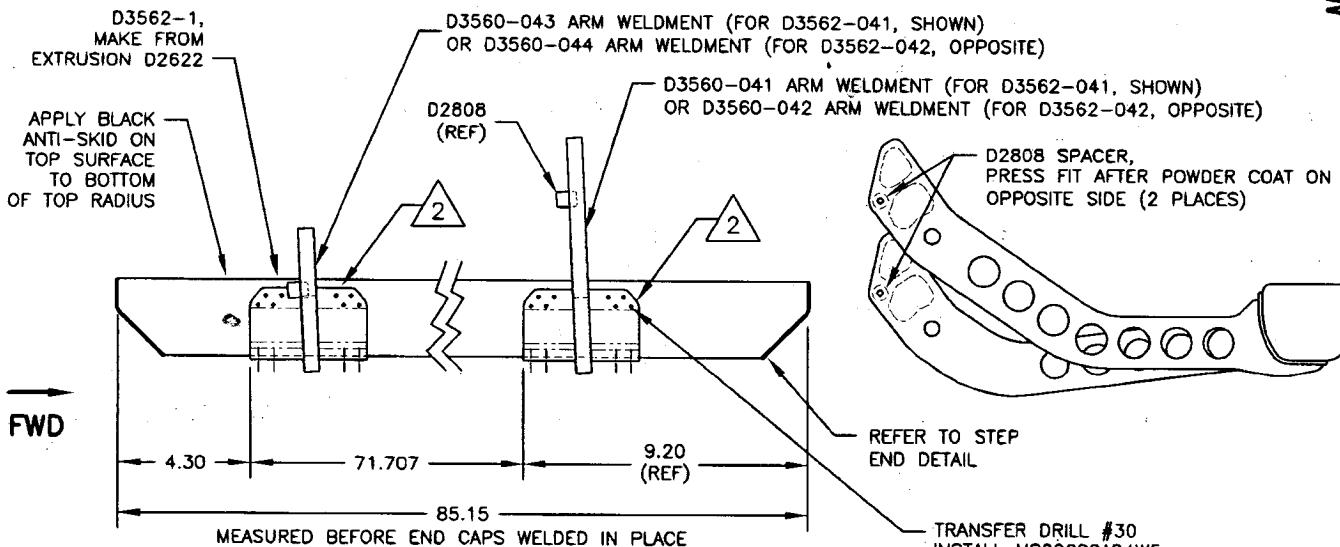
NOTE: Date & initial all entries



NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

RELEASED  
07.06.29

UNDER REVIEW  
07.10.22 DC



TRANSFER DRILL #30  
INSTALL MS20600AD4WS  
RIVET (32 PLACES),  
DEBURR & TOUCH UP HOLES  
WITH CHEMICAL CONVERSION  
COAT BEFORE RIVETING

**D3562-041 LH STEP ASSEMBLY (SHOWN)**  
**D3562-042 RH STEP ASSEMBLY (OPPOSITE)**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
  - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
  - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
  - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD
DATE	APPROVED	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
07.06.19		D3562
A	06.09.26	NEW ISSUE
B	07.01.15	ARMS NOW RIVETED TO STEP
C	07.06.19	NOW MAGBND, ADD D2808, RMV 4 RVTS

07.06.29

REV. C

SHEET 1 OF 1

SCALE

NTS

W/O:		WORK ORDER CHANGES					
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